

Work Order ID 148779

Thursday, July 07, 2016 1:49:27 PM

148779**PRELIMINARY ISSUE**

Page 1

Item ID: D3511-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 07/08/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3511	PB3 Rev B 16-10-24 9-89 DAS								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg D3511 Dwg Rev: PB3 Prog Rev: PB3 2- Deburr if necessary Identify as D3511-1								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

JUL 15 2016

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148779**PRELIMINARY ISSUE**

Page 2

Item ID: D3511-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 07/08/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130*	Small Fab	0.05							
Brake NC	Memo	0.01			DAS 30 9-89	1			JUL 20 2016
Brake NC	Bend fwd 90 deg. per dwg D3511								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									JUL 21 2016
150 *150*	Weld per dwg A/R S.S. rod Batch: <u>14123823</u>	0.00							
Large Fab	Large Fab								
	Memo	0.07							
Large Fab	weld cups as per dwg								

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148779**PRELIMINARY ISSUE** Page 3

Item ID: D3511-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 07/08/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
155									
QC	Memo	0.00							
Quality Control									
160		0.01							
160	Small Fab								
Small Fab	Memo	0.01							
Small Fab	Form as per Dwg D3511								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89DAS
30
9-89

JUL 28 2016

DAS
9
9-89

Picklist Print

Thursday, July 07, 2016 1:49:26 PM

Page 1

Work Order ID: 148779

148779

Parent Item: D3511-041

D3511-041

Parent Item Name: Wearplate Assembly

Start Date: 07/08/2016

Required Date: 07/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-05-04 JLM
IPP Rev:B New process 06-05-05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3503-1		Manufactured	No			150	Each	18.0000	8	8			
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D3503-1

Cup

**

Location

Loc Qty

Loc Code

WA001

18

127021

18

M304S188

Purchased

No

100

sf

63.9000

1.484

1.562105

M304S188

304 SHEET 0.188

**

Re 16/07/13

Location

Loc Qty

Loc Code

MAT020

63.9

M130454

63.9

1.9

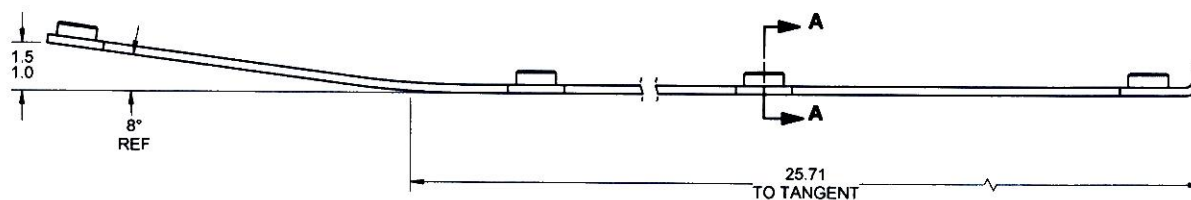
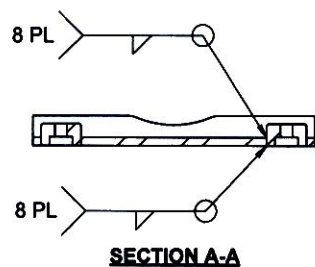
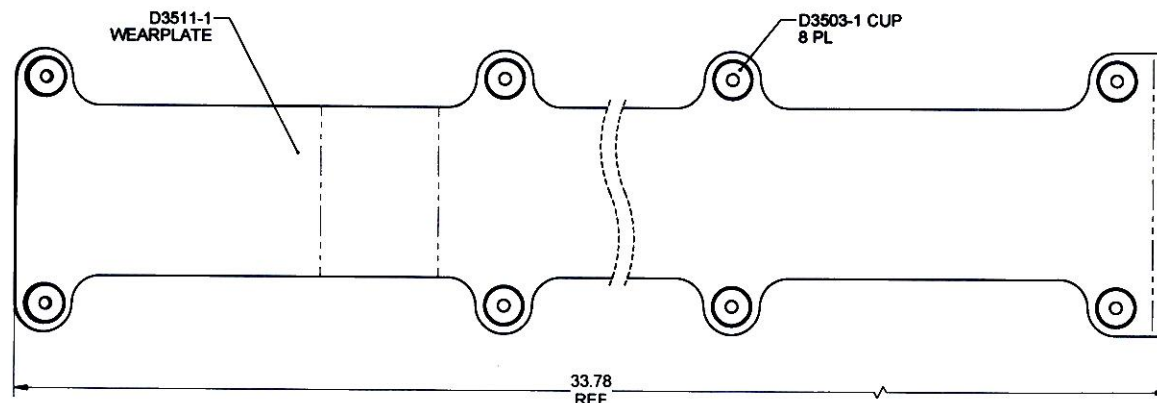
D3503-1

Rev PB1

B148020 x 8

Re 16-7-21

ITEM	QTY	P/N	DESCRIPTION
	X	D3511-041	WEARPLATE
1	1	D3511-1	WEARPLATE
2	8	D3503-1	CUP



D3511-041 WEARPLATE

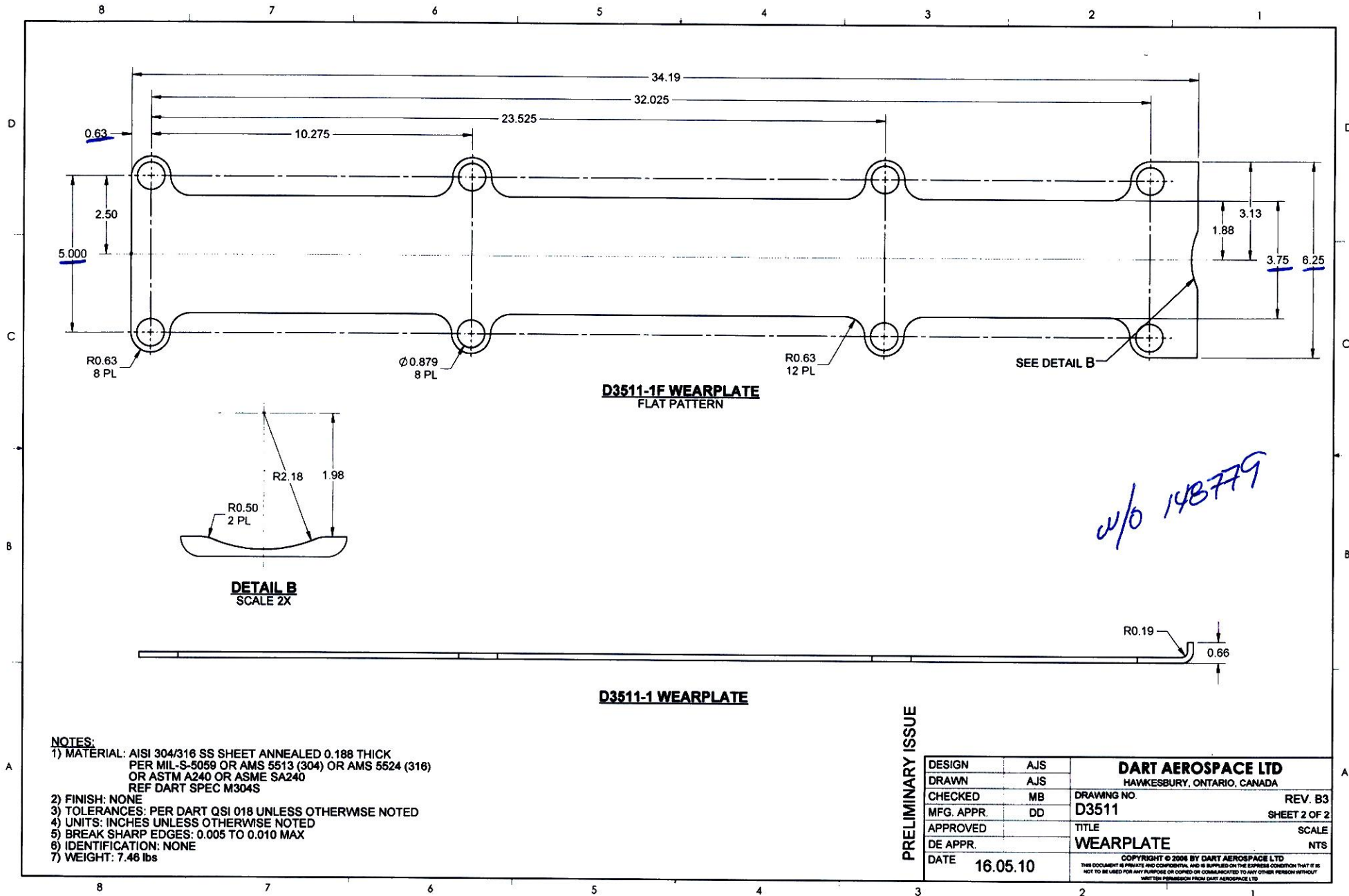
wp 148779

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 8.02 lbs

PRELIMINARY ISSUE

B	UPDATE DRAWING TO CURRENT STANDARDS. REMOVE FINISH. (SEE CIR 18-87)	AJS	18.05.10
A	NEW ISSUE	PH	06.04.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B3
MFG. APPR.	DD	D3511	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	16.05.10	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECRET-192

Thursday, September 25, 2014 7:05:07 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO25879 Receipt Dates from 9/24/2014 to 9/24/2014 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

[illegible]



740 Imperial Road North

Certificate: 977858 5

Customer: 007069 00

METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

168415

Shin Pa.

Date: 8/19/2014 Page: 1

Steel: 304/304L

Finish: 1

Corrosion: ASTM A262/02aE;180Bend-OK

Your Order: C94176

NAS Order: DS 0006133 01

PRODUCT DESCRIPTION:

STAINLESS STEEL CONT. MILL PLATE, HRAP; UNS 30400/30403
ASTM A240/13C, A483/13, A666/10; ASME SA240/13, SA480/13, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/13, SA479/13
AMS 5511H/5513J BRR; MIL-5059D AMD3(X CRN MEAS); MIL-4043B
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; QQ9766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900P, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
DM3265	05N4Y9 B		.1820	48.0000	3.110	SHEETS	096.00	30	13

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
N4Y9	US	.0190	18.1115	.2995	1.7180	.1800	.0859	8.0140	.0285	.0024
		SI %								
		.3045								

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i c r	UTS KSI	20C .2% YS KSI	20C ELONG %-2"	% Hard RB	Tail Hard
DM3265	05N4Y9	F T	93.45	50.65	50.80	88.00	86.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ASB Shaw

ABHIJEET BHAVE

8/19/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25879**

Purchase Order Date 9/23/2014

PO Print Date 9/23/2014

Page Number 1 of 2

Order From :

VC-CAM002

Ship To : DART AEROSPACE LTD

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FC 13

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

EXA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	M1010S18GA	1010/1025 SHEET .048	9/26/2014 Yes 9/26/2014		160.00 sf	\$1.50	\$239.84
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MATERIAL AS PER AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
MINIMUM YIELD TENSILE STRENGTH= 28KSI
MINIMUM ULTIMATE TENSILE STRENGTH= 42KSI
COLD ROLLED

Line Total: \$239.84

2	M304S18S	304 SHEET 0.188	9/26/2014 Yes 9/26/2014		96.00 sf	\$20.70	\$1,987.50
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MATERIAL: AISI 304/316 SS SHEET ANNEALED
AS PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR
ASME SA240

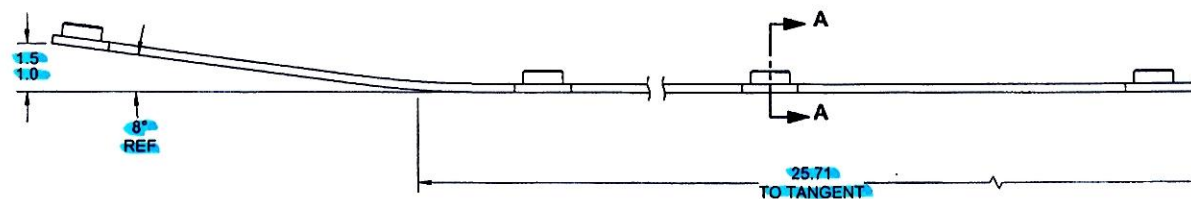
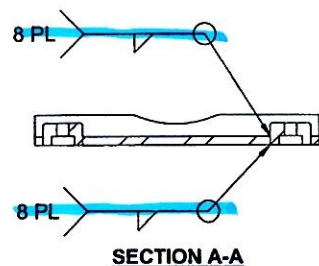
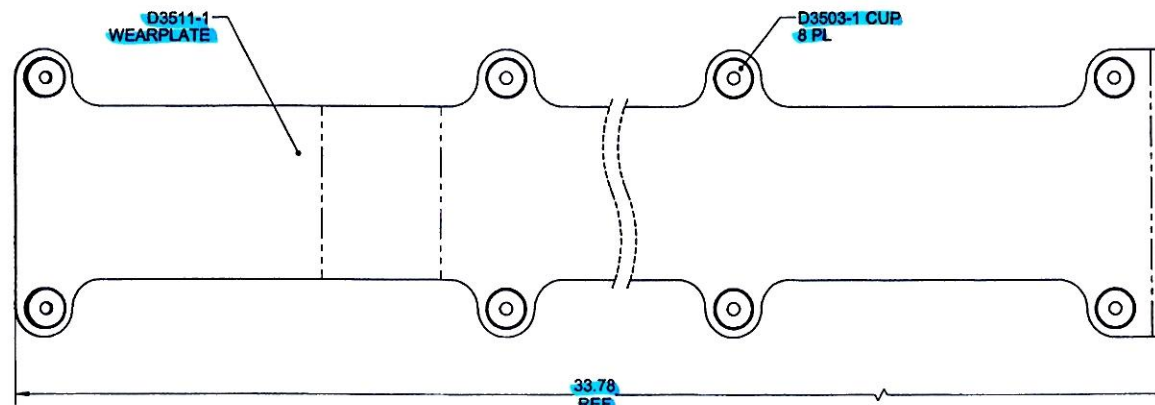
9/24/2014

Line Total: \$1,987.50

Note:

9/23/2014

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3511-041	WEARPLATE
1	1	D3511-1	WEARPLATE
2	8	D3503-1	CUP



D3511-041 WEARPLATE

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 8.02 lbs

RELEASED
2016-10-18
EIN 16-184

APPROVED

B	UPDATE DRAWING TO CURRENT STANDARDS. REMOVE FINISH. (SEE CIR 16-87)	AJS	16.05.10
A	NEW ISSUE	PH	06.04.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D3511	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	16.05.10	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

